

### ABSTRACT OF THE DISCLOSURE

A process for forming oversized circular pipe has the steps of affixing an elliptically-shaped forming head onto a spiral pipe forming machine, driving a metal strip along the forming head such that the metal strip takes on a shape of the forming head, moving said metal strip out of the forming head into a spiral pattern such that edges of the metal strip engage with each other so as to form an elliptically-shaped spiral pipe, removing the spiral pipe from the forming machine, and forming the elliptically-shaped pipe into a circular shape. The circular pipe has a diameter of greater than forty-eight inches. The forming head has an adjustable diameter.